

# Work Order ID 70245



Page 1

Wednesday, June 01, 2011 3:35:07 PM

Item ID:	D4055-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Fuel Tank Assembly					
Start Date:	6/1/2011	Start Qty:	1.00	Cust Item ID:		
Required Date:	6/29/2011	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	<i>ME</i>	Date:	<i>11-06-01</i>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4055	B

100	Weld per dwg A/R Aluminum rod Batch	<i>1103</i>	0.00
		<i>117884</i>	

Large Fab

Memo

1- weld D4023-3 cap, D3999-11 earth tab and D4008-11 hinge onto D4055-11 as per dwg D4055

2- Weld D4001-1 and D4000-5 onto D4055-1 Top

2- Weld D4055-9 and D4055-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4055-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5-Weld D4055-7 fwd end

*11.09.28 1*

# Work Order ID 70245



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Item ID:	D4055-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Fuel Tank Assembly					
Start Date:	6/1/2011	Start Qty:	1.00	Cust Item ID:		
Required Date:	6/29/2011	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									
121	Weld per dwg A/R Aluminum rod Batch: <i>M114703</i>	0.00							
Large Fab	Memo	0.00							
Large Fab	1-Weld top D4055-1								
122	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									

*11.07.30* *1* *0*

*1* *0* *BEU/08/04*

**RESEARCH DESIGN AND METHODS**

Wednesday, June 01, 2011 3:35:07 PM

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**Stop**

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**Customer:**

[illegible]

Run Start

**Stop**

[illegible]

**Insp.  
Stamp**

0.00

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0.00

## Memo

## Quality Control

\*\*\*Pressure Test as per dwg D4055\*\*\*

0.00

HandFinish

## Hand Finishing

## Memo

1- brush alodine on tank. No alodine inside

0.00

140

\_\_\_\_\_

0.00

OC

### Quality Control

# Work Order ID 70245



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Wednesday, June 01, 2011 3:35:07 PM

Item ID: D4055-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Tank Assembly

Start Date: 6/1/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/29/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

\*\*\*Mask prior to powdercoat\*\*\*  
Start Time: 8:00am  
Oven Temperature: 320°C  
Finish Time: 8:30am

(2 PS311413)  
Grey mat - 11/08/11

1 6 22 108/09

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1X 11/08/09

185

0.00



SprayPaint

Memo

0.00

Spray Painting

Seal inside of tank using Sloshing Sealer as per dwg

1 6 22 11/08/09

**Work Order ID 70245**

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Item ID: D4055-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Tank Assembly

Start Date: 6/1/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/29/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190



Small Fab

Memo

0.00

0.00

Small Fab

Assemble as per dwg

EJS 11/08/16 (2)

200



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Sulovic

(H)

220



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

n/A

**Work Order ID 70245**

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Item ID: D4055-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Fuel Tank Assembly

Start Date: 6/1/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 6/29/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

230

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

PP P72429

J

11/8/18



Packaging

Memo

0.00

Packaging

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/18 J

11-08-18  
①

# Picklist Print

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Page 1

Work Order ID: 70245

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly



Start Date: 6/1/2011

Required Date: 6/29/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 10.03.08 new issue prelim EC verified by:DD IPP Rev:B  
10.05.17 ECN10-562 DD verf:EC IPP Rev C: 10.11.23  
revised pick list EC verified by:DD IPP Rev D: 11.06.01 per D4055  
revB EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-1  Placard		Manufactured	No			190	Each	4.0000	1	1		6/5/08/16	
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
				ST104				4					
					68930			4					
D3997-5  Placard		Manufactured	No			190	Each	5.0000	2	2		6/5/08/16	
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
				ST104				5					
					65436			5					
D3997-11  Placard		Manufactured	No			190	Each	9.0000	1	1		6/5/08/16	
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
				ST104				9					
					65124			9					
D3997-17  Placard		Manufactured	No			190	Each	9.0000	1	1		6/5/08/16	
<u>Location</u> <u>Loc Qty</u> <u>Loc Code</u>													
				ST104				9					
					55410			1					
					65125			8					

B71177 (IX)

B71170 (IX)

B72614 (IX)

B72617 (IX)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Page 3

Work Order ID: 70245

Parent Item: D4055-041


Parent Item Name: Fuel Tank Assembly

Start Date: 6/1/2011


Required Date: 6/29/2011

Start Qty: 1.00


Required Qty: 1.00

✓ D3999-041 Manufactured No 100 Each 2.0000 1 1  
  
 Baffle Assembly, Aft 11.07.21


Location Loc Qty Loc Code  
 WA014 370248 2  
 65437 2

✓ D3999-043 Manufactured No 100 Each 2.0000 1 1  
  
 Baffle Assembly, Fwd 11.07.21


Location Loc Qty Loc Code  
 WA014 370249 2  
 65439 2

✓ D4000-1 Manufactured No 100 Each 5.0000 1 1  
  
 Fuel Supply Fitting 11.07.21

Location Loc Qty Loc Code  
 WA013 5  
65716 5

✓ D4000-5 Manufactured No 100 Each 3.0000 1 1  
  
 Fuel Tank Vent Fitting 11.07.28

Location Loc Qty Loc Code  
 WA013 372427 3  
 65444 3

✓ D4000-9 Manufactured No 100 Each 5.0000 3 3  
  
 Grommet 11.07.28

Location Loc Qty Loc Code  
 WA013 370250 5  
 65109 5

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Shop Packet Print

Page 3

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 4

Work Order ID: 70245

Parent Item: D4055-041











Parent Item Name: Fuel Tank Assembly

Start Date: 6/1/2011

Required Date: 6/29/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4000-043  Drain Fitting Assembly, Fwd	Manufactured	No	100	Each	1.0000		1	<u>11.07.27</u>									
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>WA013 <u>B72449</u></td><td>1</td><td><u>1</u></td></tr><tr><td>65442</td><td>1</td><td></td></tr></table>									Location	Loc Qty	Loc Code	WA013 <u>B72449</u>	1	<u>1</u>	65442	1	
Location	Loc Qty	Loc Code															
WA013 <u>B72449</u>	1	<u>1</u>															
65442	1																
✓ D4000-045  Fuel Pickup Fitting Assembly	Manufactured	No	100	Each	2.0000		1	<u>11.07.29</u>									
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>WA013 <u>B71669</u></td><td>2</td><td><u>1</u></td></tr><tr><td>68385</td><td>2</td><td></td></tr></table>									Location	Loc Qty	Loc Code	WA013 <u>B71669</u>	2	<u>1</u>	68385	2	
Location	Loc Qty	Loc Code															
WA013 <u>B71669</u>	2	<u>1</u>															
68385	2																
✓ D4000-041  Drain Fitting Assembly, Aft	Manufactured	No	100	Each	2.0000		1	<u>11.07.27</u>									
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>WA013 <u>B72452</u></td><td>2</td><td><u>1</u></td></tr><tr><td>69096</td><td>2</td><td></td></tr></table>									Location	Loc Qty	Loc Code	WA013 <u>B72452</u>	2	<u>1</u>	69096	2	
Location	Loc Qty	Loc Code															
WA013 <u>B72452</u>	2	<u>1</u>															
69096	2																
✓ D4001-1  Fitting	Manufactured	No	100	Each	4.0000		1	<u>11.07.27</u>									
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>WA013</td><td>4</td><td><u>1</u></td></tr><tr><td><u>66840</u></td><td>4</td><td></td></tr></table>									Location	Loc Qty	Loc Code	WA013	4	<u>1</u>	<u>66840</u>	4	
Location	Loc Qty	Loc Code															
WA013	4	<u>1</u>															
<u>66840</u>	4																
✓ D4008-11  Hinge Half	Manufactured	No	100	Each	4.0000		1	<u>11.07.28</u>									
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST108 <u>365445</u></td><td>4</td><td><u>1</u></td></tr><tr><td>67650</td><td>4</td><td></td></tr></table>									Location	Loc Qty	Loc Code	ST108 <u>365445</u>	4	<u>1</u>	67650	4	
Location	Loc Qty	Loc Code															
ST108 <u>365445</u>	4	<u>1</u>															
67650	4																

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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Work Order ID: 70245

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/1/2011

Required Date: 6/29/2011

Start Qty: 1.00

Required Qty: 1.00



D4008-041

Manufactured No

190 Each 0.0000

1

1

Fuel Filler Splash Guard Assembly

D4023-3

Manufactured No

100 Each 0.0000

1

1

Cap and Flange

D4025-1

Manufactured No

100 Each 2.0000

1

1

Fuel Quantity Sender

Location

Loc Qty

Loc Code

ST241A

2

65131

2

Manufactured No

100 Each 5.0000

1

1

D4055-11



Tank Front and Bottom

Location

Loc Qty

Loc Code

WA013

5

65447

2

68500

3

Manufactured No

100 Each 6.0000

1

1

D4055-9



Tank Back

Location

Loc Qty

Loc Code

WA013

6

63948

1

65451

2

66842

3

B 72200 (X)

EP 11/08/16

K 11.07.29 B 70204

EP 11/08/11

B 71765 (X)

K 11.07.21

1

K 11.07.21

1

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# Picklist Print

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Page 6

Work Order ID: 70245

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/1/2011

Required Date: 6/29/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4055-7



Tank Fwd End

Manufactured No

100

Each

2.0000

1

1



6/11.07.28

Location

Loc Qty

Loc Code

WA014

370251

2

65450

2

1

✗ D4055-5



Tank Upper Cut Out

Manufactured No

100

Each

6.0000

1

1



6/11.07.28

Location

Loc Qty

Loc Code

ST119

2

65449

2

WA013

67737

4

4

1

✓ D4055-3



Tank Aft End

Manufactured No

100

Each

4.0000

1

1



6/11.07.20

Location

Loc Qty

Loc Code

WA

870447

2

68501

2

WA014

65448

2

2

1

✓ D4055-1



Tank Top

Manufactured No

100

Each

4.0000

1

1



6/11.07.28

Location

Loc Qty

Loc Code

WA

2

68502

2

WA013

65446

2

2

1

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Page 6



# Picklist Print

Wednesday, June 01, 2011 3:35:01 PM

Page 7

Work Order ID: 70245

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 6/1/2011

Required Date: 6/29/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4057-1  
Retaining Ring

Manufactured No

100

Each

17.0000

3

3



11-07-28

Location

Loc Qty

Loc Code

WA013

17

55826

17

3

Purchased

No

190

Each

22.0000

5

5



5/11/08/16

Location

Loc Qty

Loc Code

ST350

22

114941

2

116704

20

5

Purchased

No

190

Each

2,432.000

5

5



5/11/08/16

Location

Loc Qty

Loc Code

ST298

2432

116583

432

117291

1000

117505

500

117601

500

5

Manufactured

No

190

Each

0.0000

1

1



5/11/08/16

D4404-1  
Cushion

B 70247 (IX)

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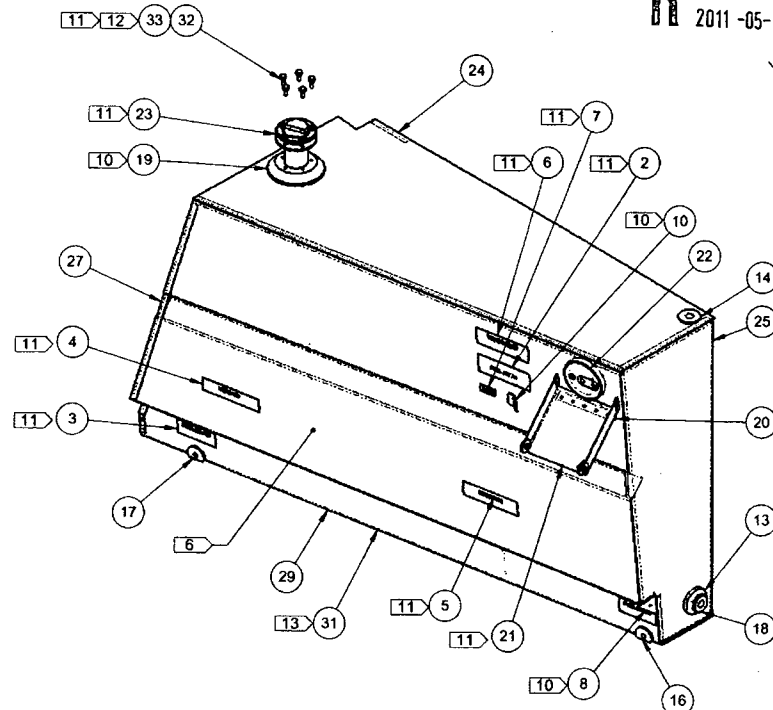
Page 7

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4055-041	FUEL TANK ASSEMBLY
2	1	D3997-1	PLACARD "FUEL JET A1"
3	2	D3997-5	PLACARD "AUX FUEL DRAIN"
4	1	D3997-11	PLACARD "LOADING"
5	1	D3997-17	PLACARD "STOWAGE"
6	1	D3997-29	PLACARD "WARNING"
7	1	D3997-43	PLACARD "EARTH"
8	1	D3999-7	CORNER
9	1	D3999-9	ANGLE
10	1	D3999-11	EARTH TAB
11	1	D3999-041	BAFFLE ASSEMBLY, AFT
12	1	D3999-043	BAFFLE ASSEMBLY, FWD
13	1	D4000-1	FUEL SUPPLY FITTING
14	1	D4000-5	FUEL TANK VENT FITTING
15	3	D4000-9	GROMMET
16	1	D4000-041	AFT FUEL SUMP DRAIN ASSEMBLY
17	1	D4000-043	FORWARD FUEL SUMP DRAIN ASSEMBLY
18	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
19	1	D4001-1	FITTING
20	1	D4008-11	TANK HINGE HALF
21	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
22	1	D4023-3	FUEL CAP
23	1	D4025-1	FUEL SENDER
24	1	D4055-1	TANK TOP
25	1	D4055-3	TANK AFT END
26	1	D4055-5	TANK UPPER CUT OUT
27	1	D4055-7	TANK FORWARD END
28	1	D4055-9	TANK BACK
29	1	D4055-11	TANK FRONT AND BOTTOM
30	3	D4057-1	RETAINING RING
31	1	D4404-13	CUSHION
32	5	AN3H5A	BOLT
33	5	NAS1149D0363J	WASHER

# NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: TOUCH UP CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-041" USING D2729-1 RED DECAL
- 7) WEIGHT: 27.57 lbs
- 8) WELD PER DART QSI 004
- 9) CAP ALL TANK ACCESS POINTS AND PRESSURIZE TANK TO 1.5 PSI AFTER ASSEMBLY. VERIFY NO LEAKS
- 10) MASK PRIOR TO POWDER COAT
- 11) INSTALL AFTER POWDER COAT. REMOVE TEXTURED FINISH LOCALLY PRIOR TO INSTALLATION
- 12) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
- 13) INSTALL CUSHION AFTER POWDER COAT USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED.

## D4055-041 FUEL TANK ASSEMBLY



B	MOVE CAP POSITION AND CHANGE CAP DESIGN, CHANGE FINISH REQUIREMENTS FOR ALL PARTS, ADD CUSHION UNDER TANK, CORRECT PART NUMBERS	HS	11.05.12
A	NEW ISSUE	HS	10.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.05.12		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4055	REV. B SHEET 1 OF 15
TITLE TANK	SCALE NTS
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**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

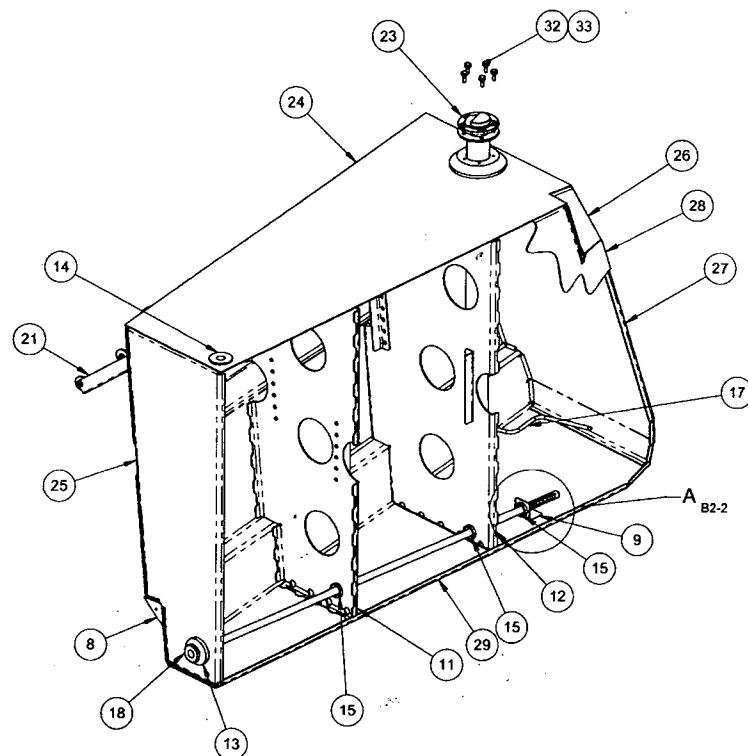
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

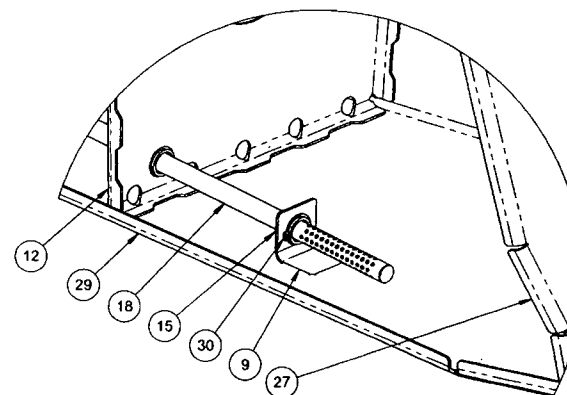
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**RELEASED**  
2011-05-30  
*MD*



**D4055-041 FUEL TANK ASSEMBLY**  
**D4055-9 TANK BACK REMOVED**  
**TO SHOW INTERIOR DETAIL**



**DETAIL A**  
**ROTATED FOR CLARITY**  
**SCALE 2X**

B6-2

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 2 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	11.05.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

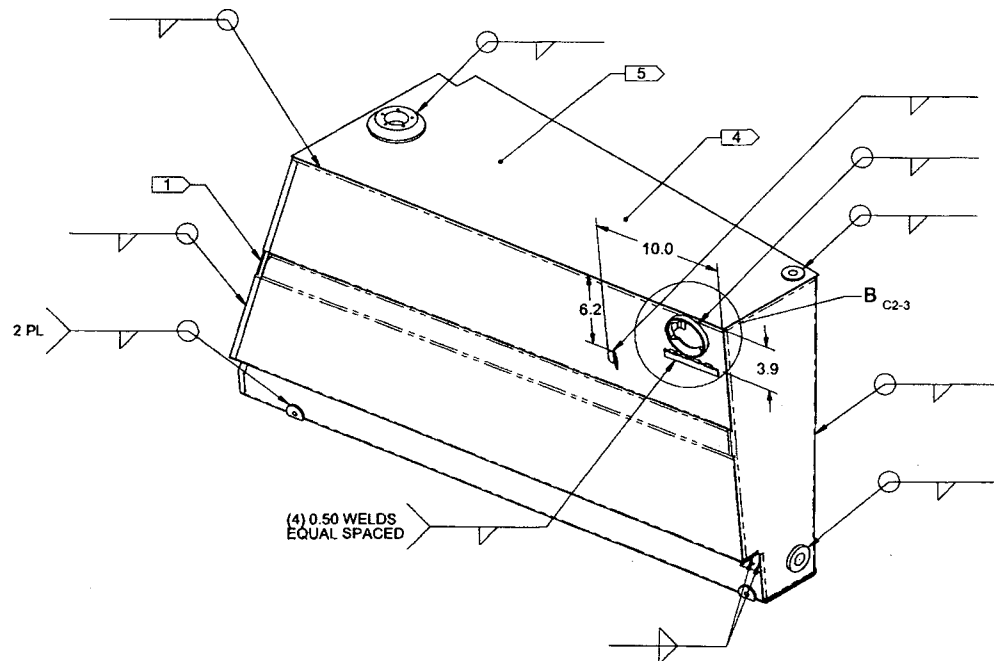
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

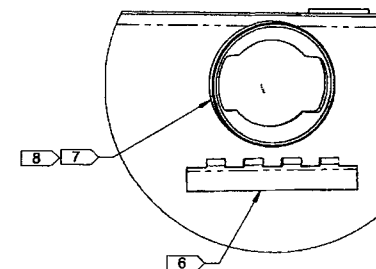
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



(4) 0.50 WELDS  
EQUAL SPACED

# **D4055-041 FUEL TANK ASSEMBLY WELDING DETAIL**



**DETAIL B  
ROTATED FOR CLARITY  
SCALE 2X**

C4-3

**RELEASED**  
2011-05-30

## **NOTES:**

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED
  - END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
  - FWD AND AFT DRAIN TUBES EXTEND TO CENTER OF TANK
  - ALL SWarf REMOVED
- 3) AFTER FINAL ASSEMBLY, SLOSH TANK WITH MIL-S-4383 OR EQUIVALENT (PR-1005-L BUNA-N-SLOSH)
- 4) ACCEPTABLE TO DRILL 6 (TYP)  $\varnothing 0.312$  HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) ACCEPTABLE TO DRILL 7 (TYP)  $\varnothing 0.312$  HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 6) CENTER HINGE BELOW FUEL CAP FLANGE
- 7) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 8) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D4055</b>	SHEET 3 OF 15
APPROVED		TITLE	SCALE
DE APPR.		<b>TANK</b>	NTS
DATE	11.05.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

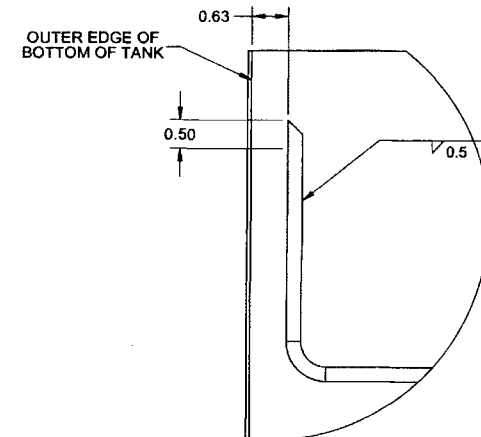
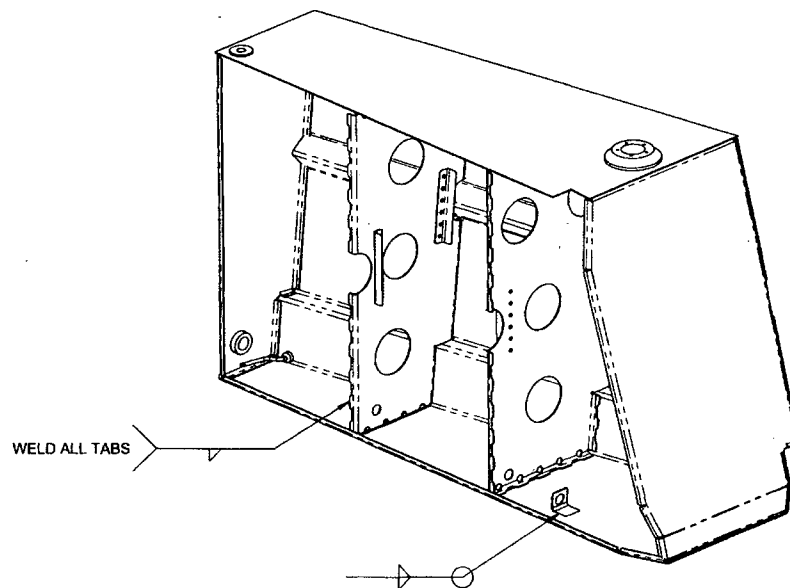
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



**DRAIN TUBE INSTALLATION - TYP**  
**VIED FROM ABOVE**  
**FWD END SHOWN, AFT END OPPOSITE**

**D4055-041 FUEL TANK ASSEMBLY**  
**WELDING DETAIL**

**RELEASED**  
 2011-05-30  
 JMT

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 4 OF 15
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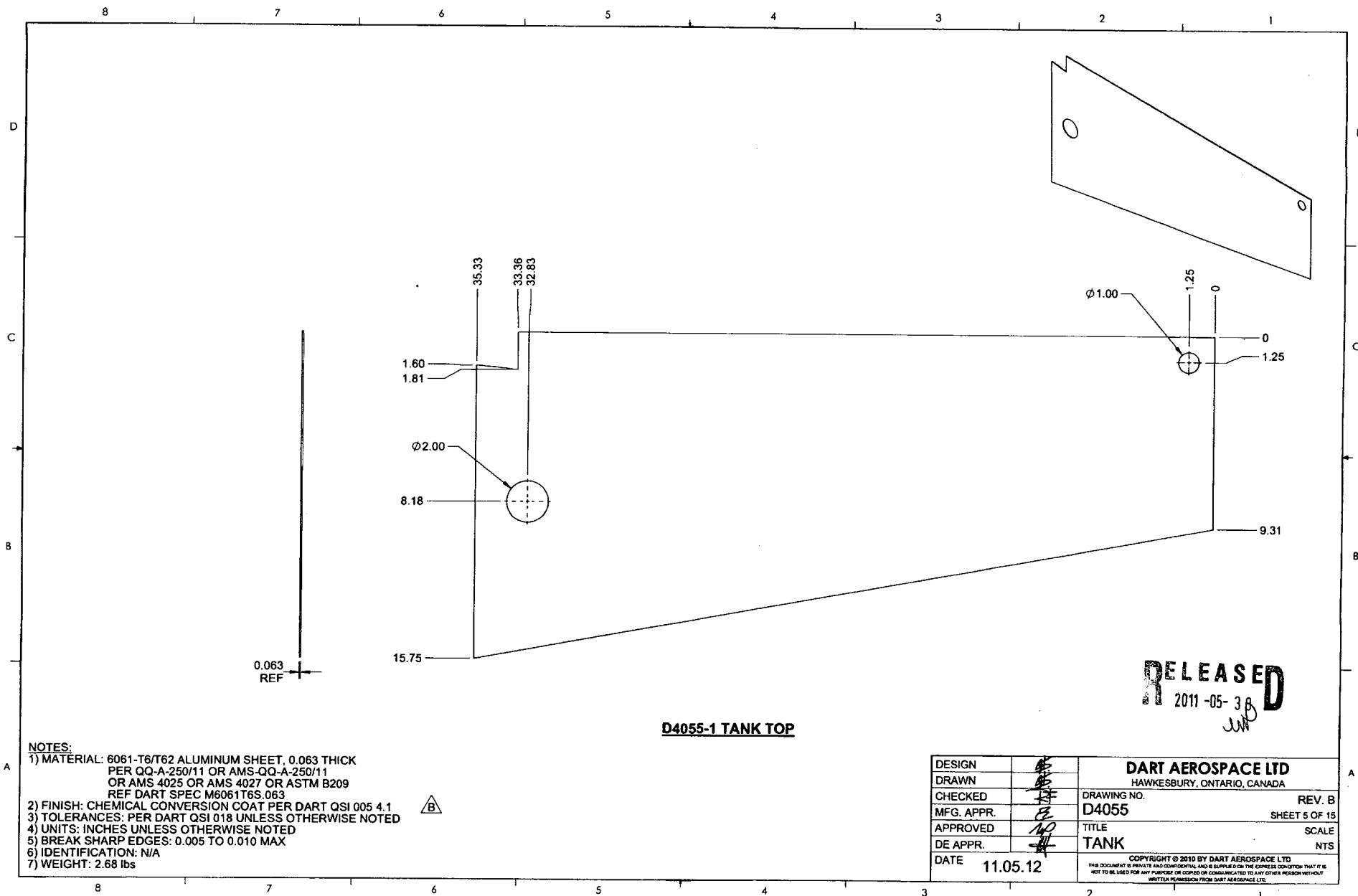
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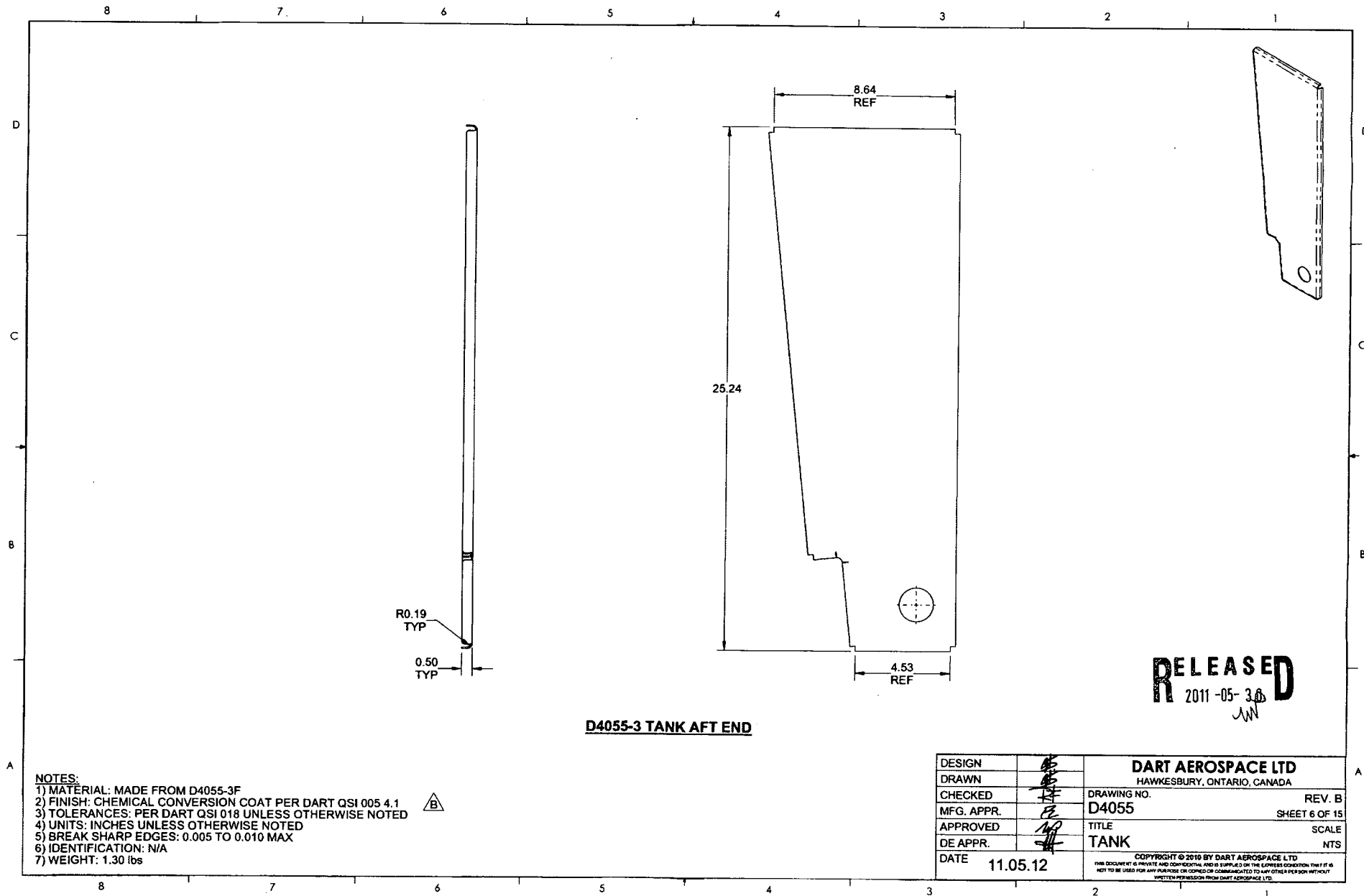
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



- NOTES:
- 1) MATERIAL: MADE FROM D4055-3F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.30 lbs



**RELEASED**  
2011-05-30

DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO. <b>D4055</b>	REV. B
MFG. APPR.			SHEET 6 OF 15
APPROVED		TITLE	SCALE
DE APPR.		<b>TANK</b>	NTS
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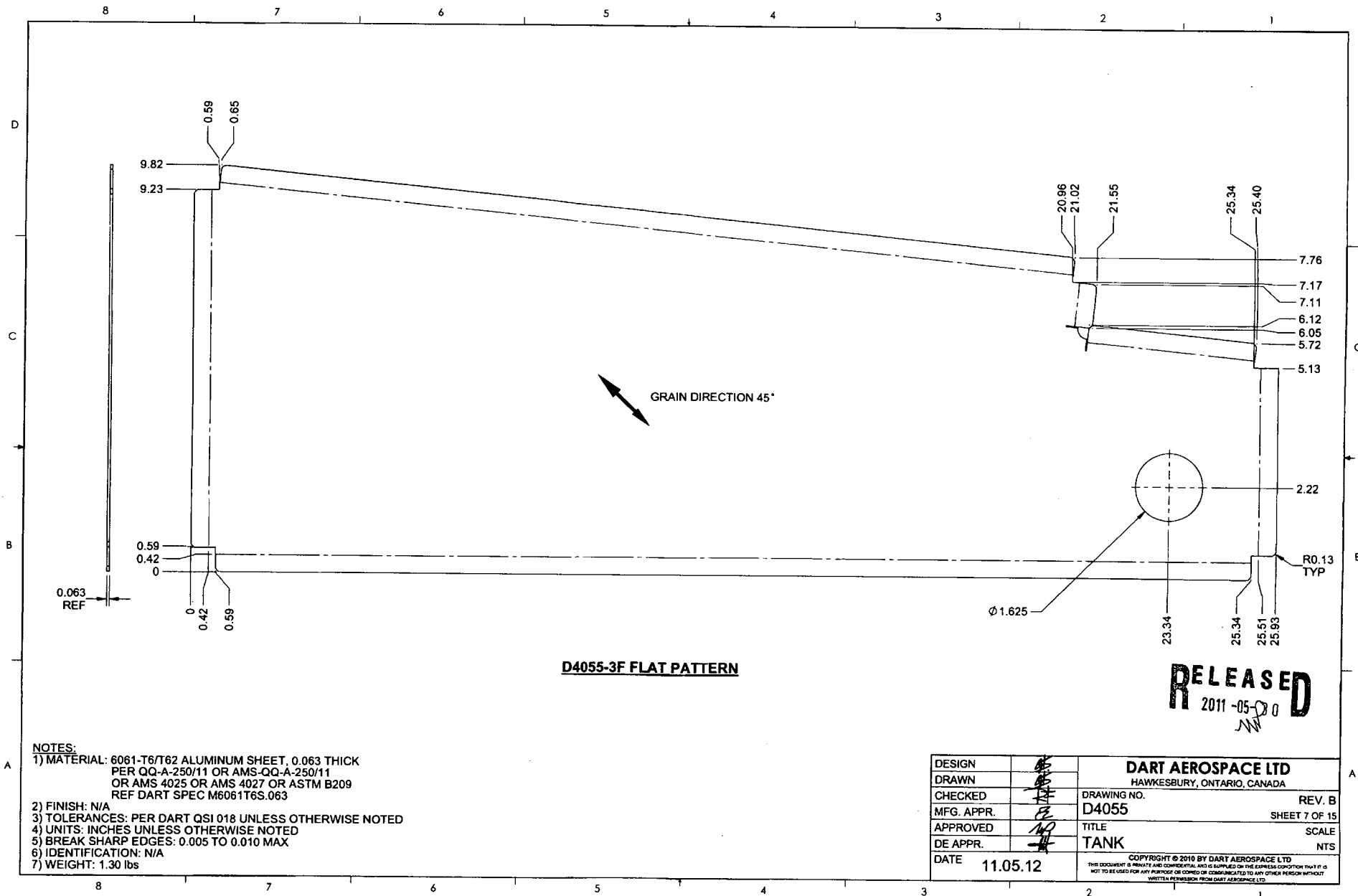
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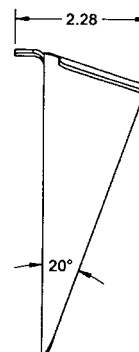
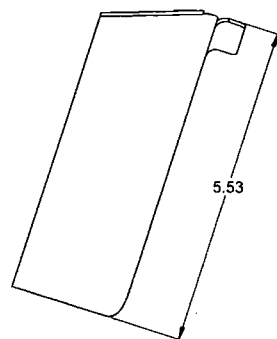
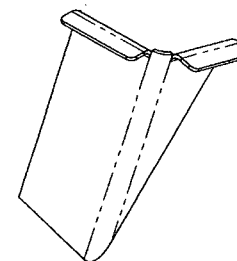
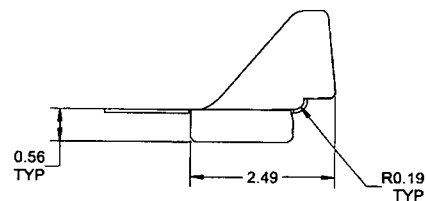
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# **D4055-5 UPPER CUT OUT**

**RELEASED**  
2011-05-30  
JW

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-5F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.10 lbs



DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. <b>D4055</b>
MFG. APPR.		REV. <b>B</b>
APPROVED		TITLE <b>TANK</b>
DE APPR.		SCALE <b>NTS</b>
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SHEET 8 OF 15



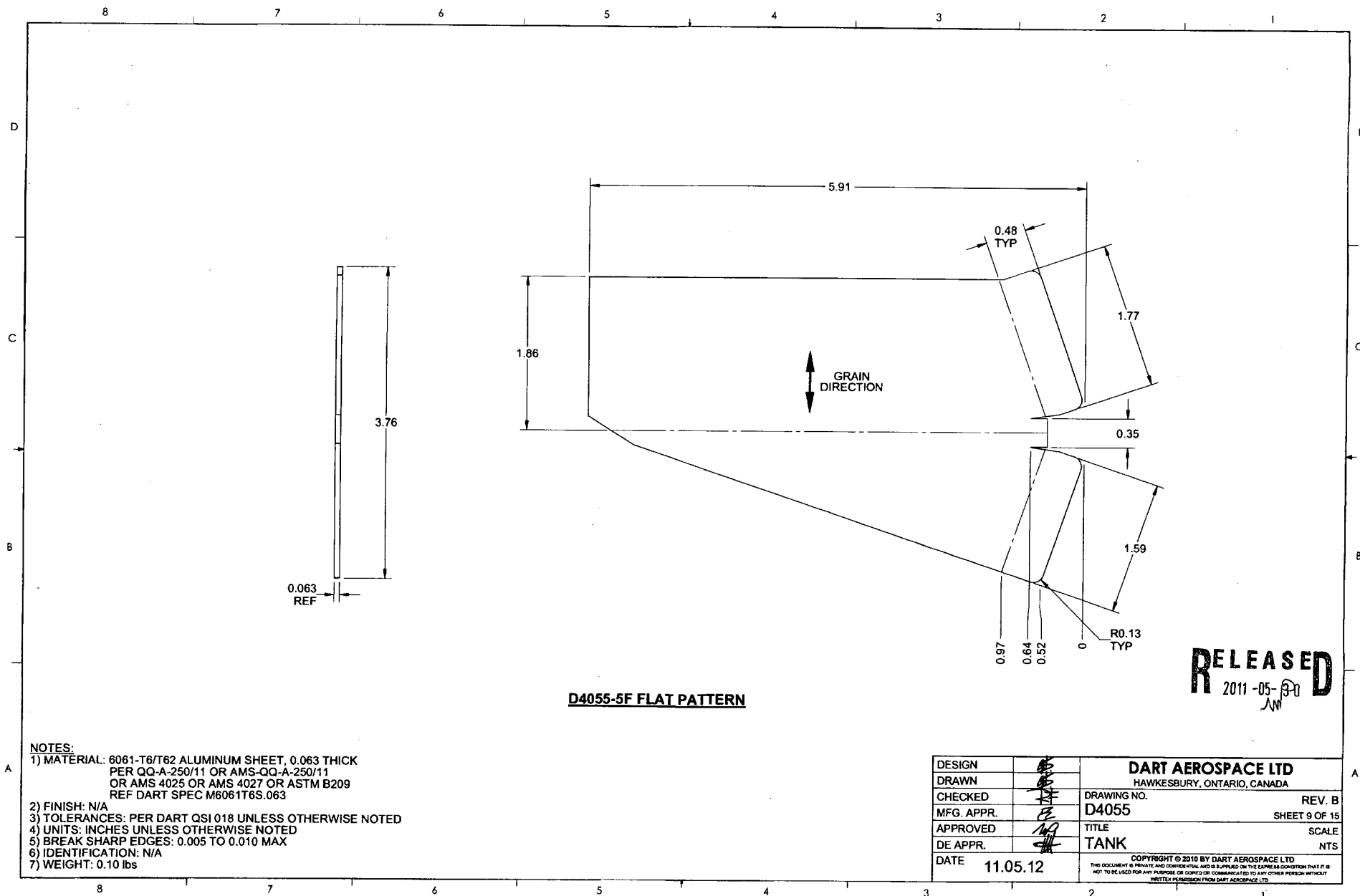
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



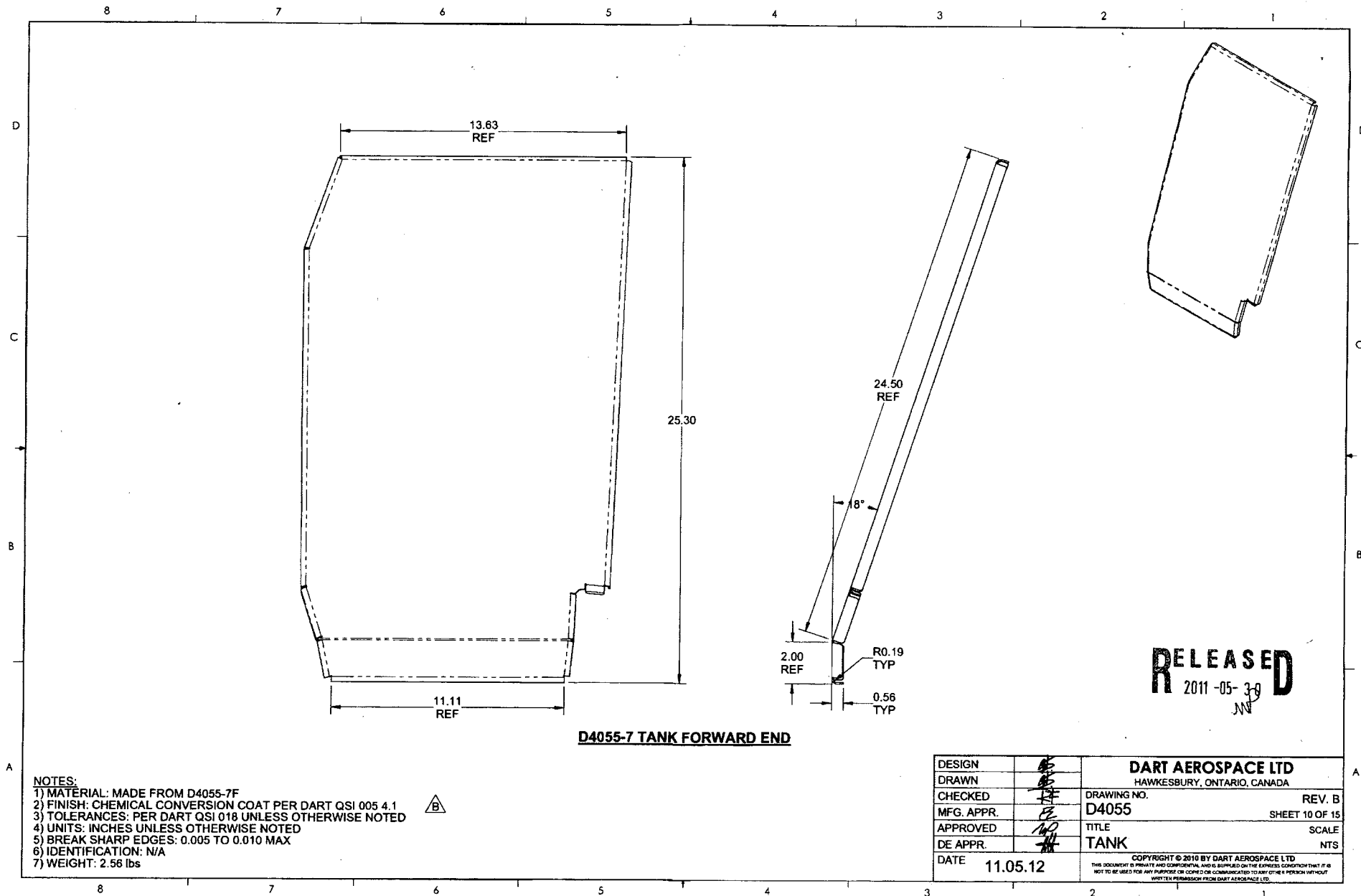
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries









**NOTES:**

- 1) MATERIAL: MADE FROM D4055-7F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs



**RELEASED**  
2011-05-30  
JN

DESIGN		<b>DART AEROSPACE LTD</b>	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

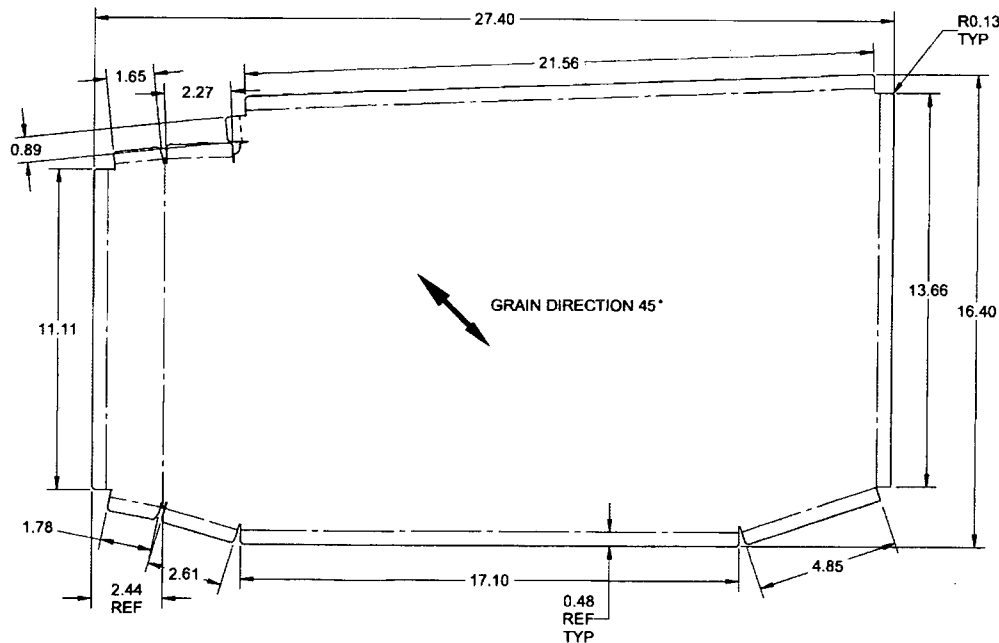
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D

C

B

0.063  
REF









**D4055-7F FLAT PATTERN**

**RELEASED**  
2011-05-10  
JW

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs

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8 7 6 5 4 3 2 1

A

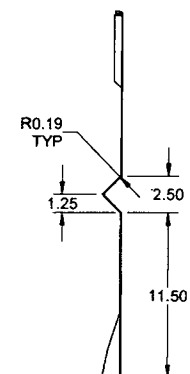
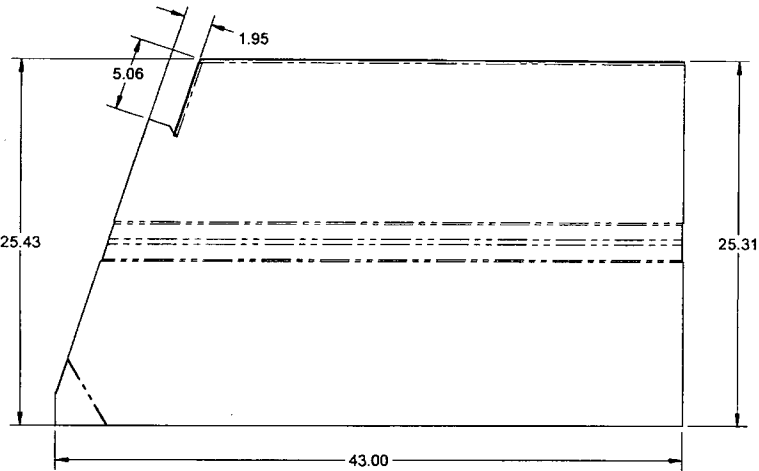
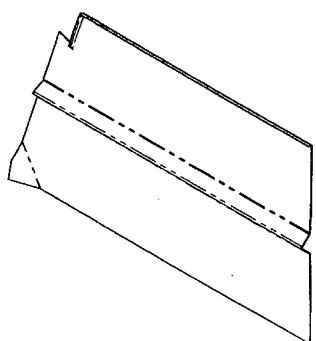
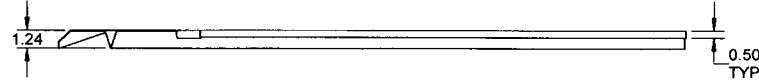
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries









D4055-9 TANK BACK

RELEASED  
2011-05-30  
JW

- NOTES:
- 1) MATERIAL: MADE FROM D4055-9F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 6.41 lbs

B

DESIGN		<b>DART AEROSPACE LTD</b>	
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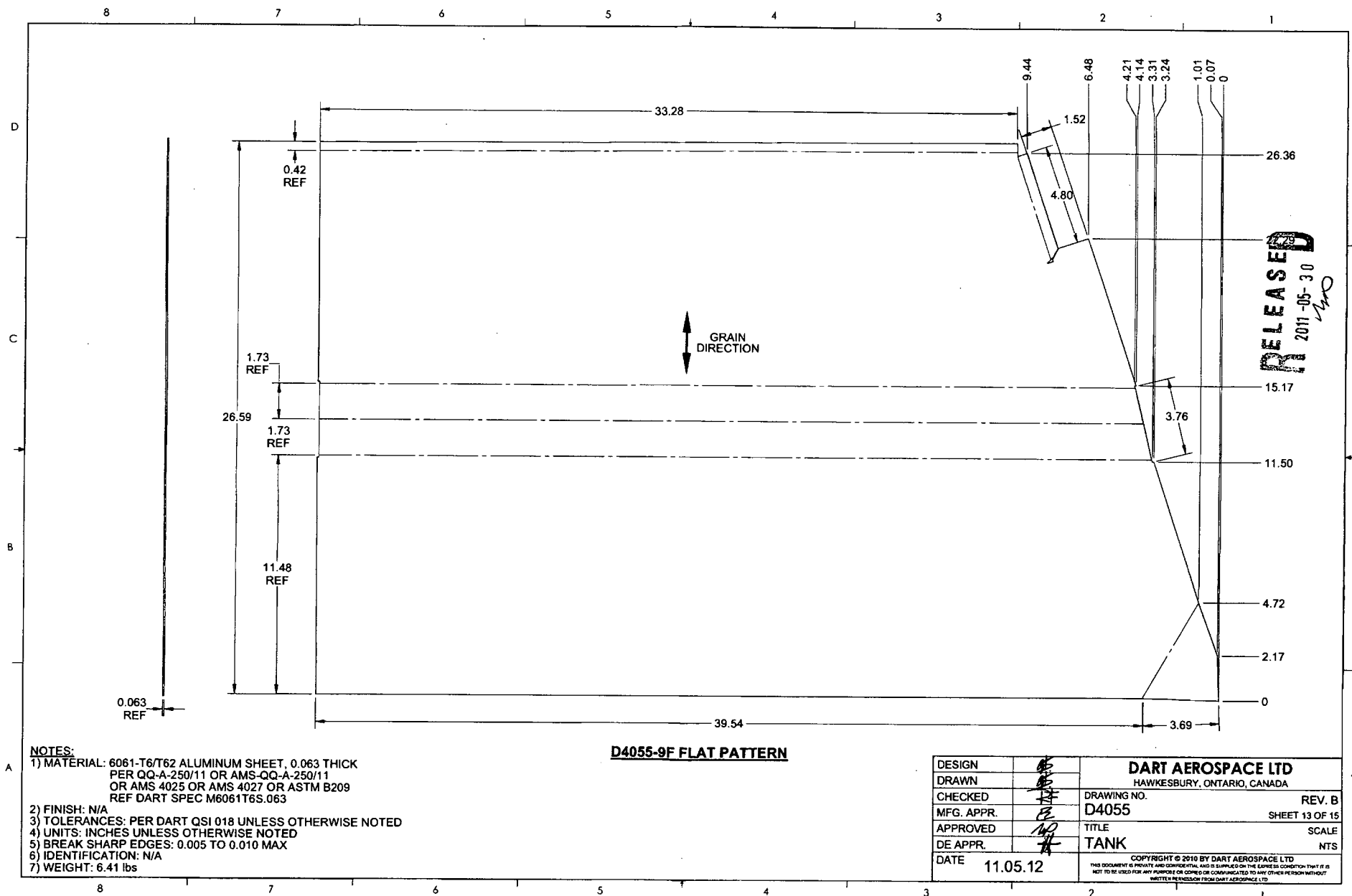
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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2011-05-30

# Dart Aerospace Ltd

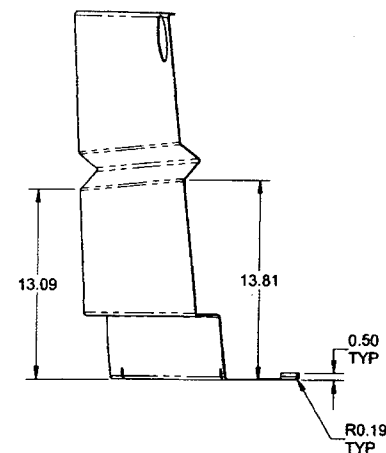
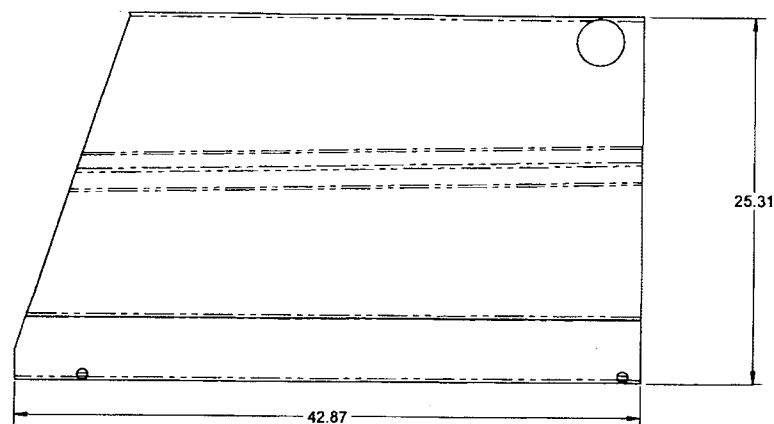
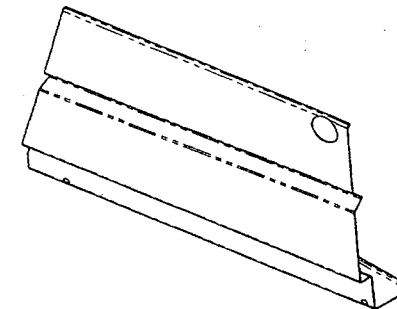
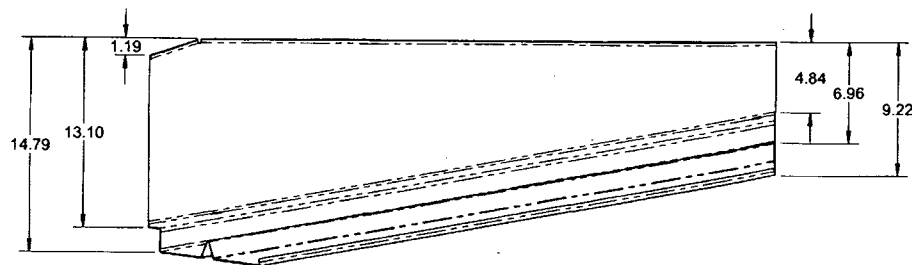
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			







**NOTE:** Date & initial all entries



**D4055-11 TANK FRONT AND BOTTOM**

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-11F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 9.32 lbs



DESIGN		<b>DART AEROSPACE LTD</b>	
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2011-05-30

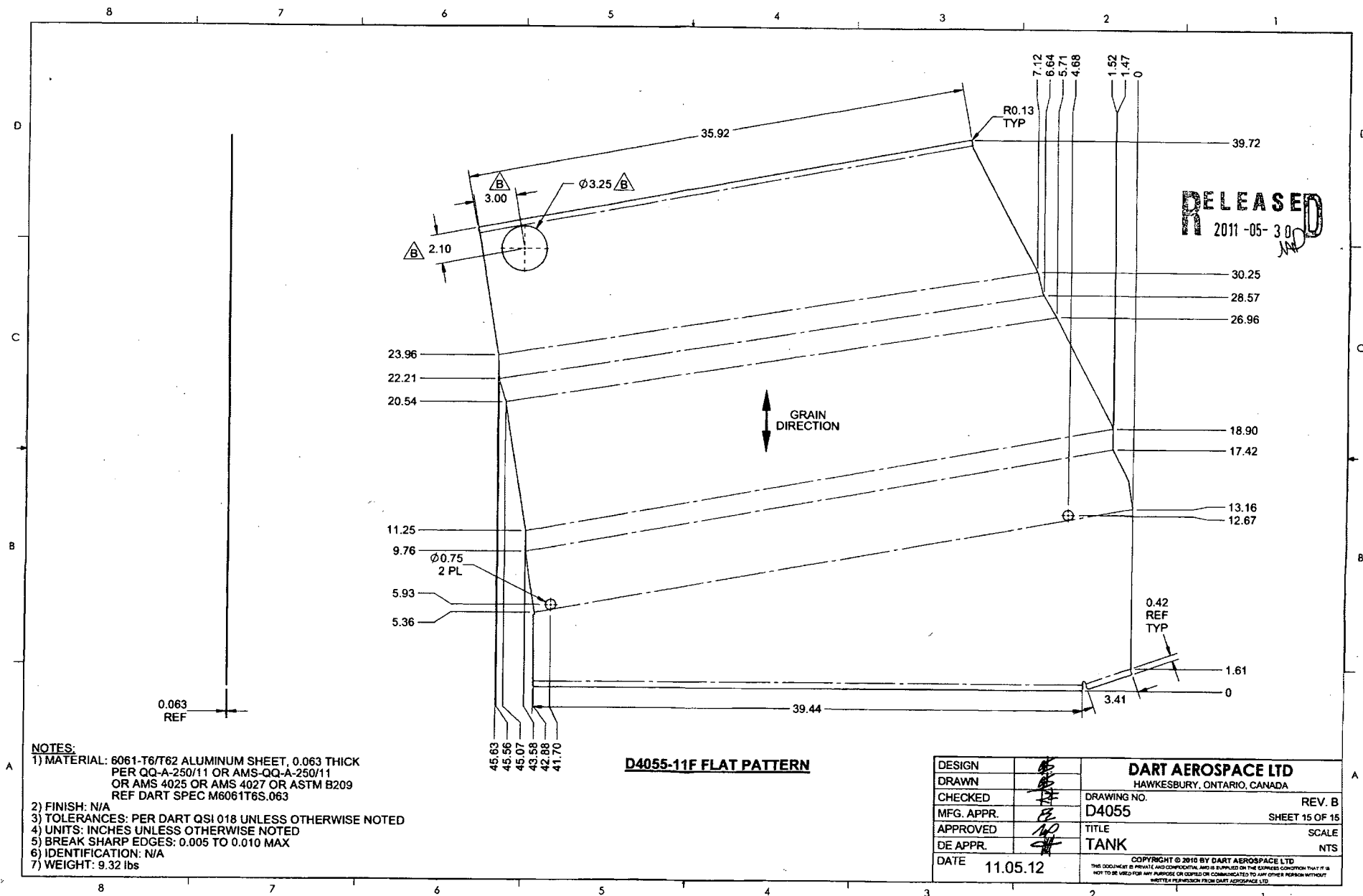
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries